

Work Order ID 60919

Monday, July 26, 2010 3:32:40 PM



Page 1

Item ID: D3852-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 7/26/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*PL*Date: *10-7-26* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3852

Rev A

100

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1- pick D3166-3 to cut D3852-1 rib (LH) as per dwg D3852 using DT9440 jig

2- drill hole (3/16") in D3852-1 using DT9439 jig and open to finish size as per dwg D3852

3- c'sink hole as per dwg

SAD 10-07-26

4- remove identification markings

5- deburr

6- weld D3759-1 bushing as per dwg D3852

A/R ER316 S.S. Rod Batch: *M 109213*

7- grind bushing weld flush as per dwg dwg D3852

8- deburr hole if necessary

(2) Cpl 10-07-28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

② 10.07.29

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/129

x2
-010

150

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

S/A
10-07-29

2

W/O:		WORK ORDER CHANGES					
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Page 3

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/29 HJ

B/10-7-29

(2)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, July 26, 2010 3:32:45 PM

Page 1

Work Order ID: 60919

Parent Item: D3852-041

Parent Item Name: Rib Assembly





Start Date: 7/26/2010

Required Date: 8/3/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3166-3  Basket Hoop		Manufactured	No			100	Each	10.5682	0.18	0.378947			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		10.56822105							
				55697		2.1053E-05							
				59266		4.5682				0.378947			
				60270		6							
D3759-1  Bushing		Manufactured	No			100	Each	91.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		91							
				54072		9							
				60241		40							
				60719		42							

SAD 10-07-27

0.378947

LPL 10-07-28

(2)

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

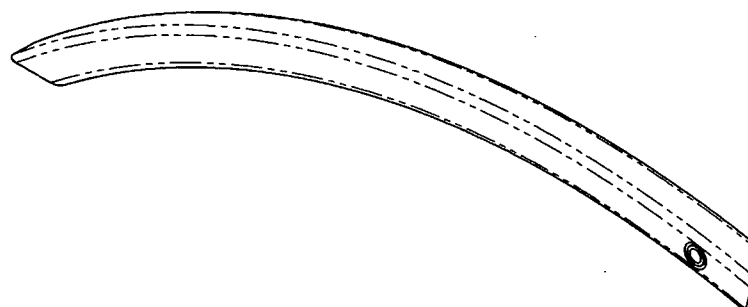
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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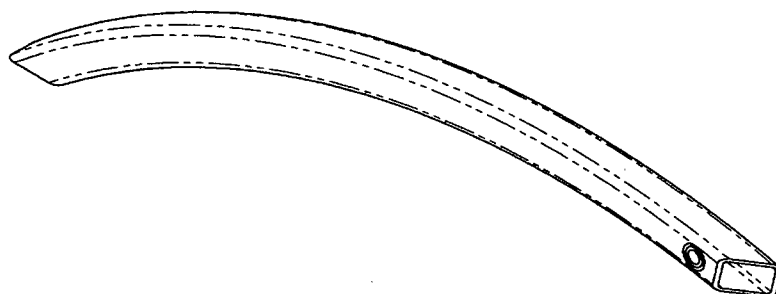
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB



D3852-041 RIB ASSEMBLY



D3852-042 RIB ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60949
08-10-7-29

RELEASE
08/11/07

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.83 lbs EACH
 - 8) WELDING: PER QSI 004

A	NEW ISSUE	DESCRIPTION	MB	08.11.07
REV.			BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.11.07			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3852** REV. A
SHEET 1 OF 3
TITLE **RIB ASSEMBLY** SCALE NTS

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8 7 6 5 4 3 2 1

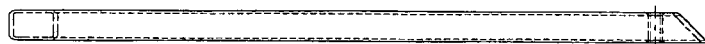
W/O:		WORK ORDER CHANGES						
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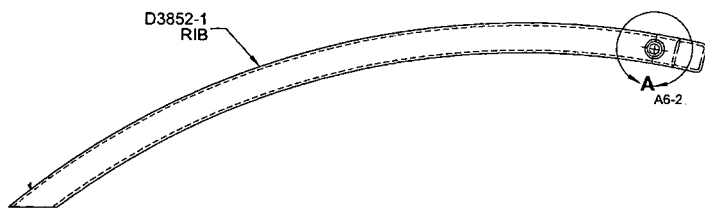
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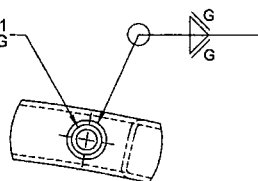


D3852-1
RIB

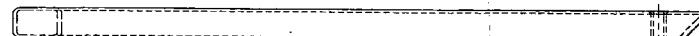


D3852-041 RIB ASSEMBLY

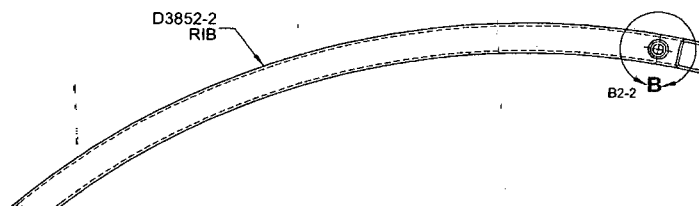
D3759-1
BUSHING



DETAIL A
SCALE 2X C5-2

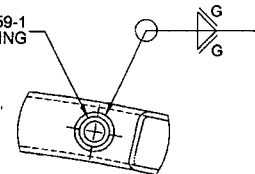


D3852-2
RIB



D3852-042 RIB ASSEMBLY

D3759-1
BUSHING



DETAIL B
SCALE 2X C2-2

u/o 60919

RELEASED
08/11/07

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>185</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>185</i>	D3852	SHEET 2 OF 3
APPROVED	<i>185</i>	TITLE	SCALE
DE APPR.	<i>185</i>	RIB ASSEMBLY	NTS
DATE	08.11.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

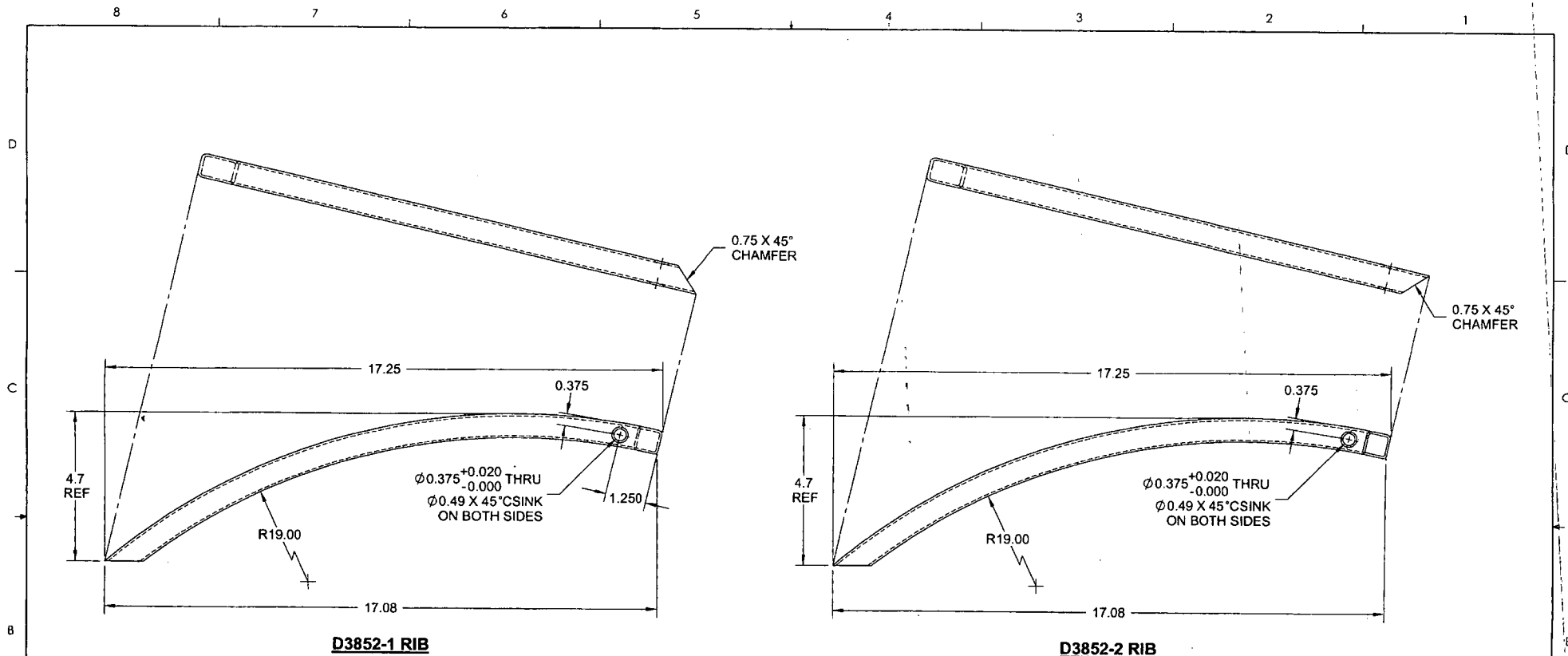
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w/o 60919

RELEASED

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL. REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.82 lbs EACH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3852	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSEMBLY	NTS
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